

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025054**Date Inspected:** 20-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

OBG –Bay 14

This QA Inspector observed the following work in progress,

Shielded Metal Arc Welding (SMAW)

Weld joint- 119/ 120, Located on Floor beam I rib, PP 128.7 in Segment 14W –SEG 3020B. Welder is identified as 067609. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

Weld joint- 290, Located on Bottom plate to I rib, PP 127.5 in Segment 14W –SEG 3020AZ. Welder is identified as 045246. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-TC-U4B-FCM-1.

Repair welding of Weld joint- 001, Located on Deck plate in Segment 14W –SEG 3020E. Welder is identified as 045196. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) –Esab- Repair.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

## Flux cored Arc Welding (FCAW)

Weld joint- 201, Located on Floor beam I rib, PP 127 in Segment 14W –SEG 3020M. Welder is identified as 067888. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-Esab.

## Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification no. 9538

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a TL 6028 MT report for this date. The member is identified as OBG Lift 14W components. The weld designations reviewed are as follows:

SEG 3020 AZ – Jt. nos -135~162, 164~208, 210 ~259

For further information's, see the pictures below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

No relevant Conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

<b>Inspected By:</b>	Baskar,Govindarajan	Quality Assurance Inspector
----------------------	---------------------	-----------------------------

---

<b>Reviewed By:</b>	Clifford,William	QA Reviewer
---------------------	------------------	-------------

---